



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE105-31702W19-9

Job Sheet 198239



DAS

21

9-89

Part No: RBE105-31702W19-9

Job Qty: 2 pcs

6 pcs.

Part Name: Washer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/24/19

Job Tracking No:

Due Date: 8/30/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE105-31702W19 Rev 2 IPP Rev. A 19.07.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time		
100	Conventional Lathe - 1	2 pcs	8/30/19	8/30/19	0.00	4.00	Conventional Lathe - 1		
							Conventional Lathe - 2		
110	QC 2	2 pcs	8/30/19	8/30/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

1/19/8/22



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CANADA
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www.dartaerospace.com

Container No: S207798



Part: RBE105-31702W19-9

Job No: 198239

Serial No/Batch: S207798

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 08/21/19

120 QC 8	2 pcs	8/30/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	FW 19/08/22
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Outsource - 13 - Zinc Plating	2 pcs	8/30/19		GRO002-VC	182019-08-26
140 Packaging 2-1 - Receive - B4B	2 pcs	8/30/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DP SEP 03 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
150 QC 6	2 pcs	8/30/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	

160 Packaging 3-1 - Stock - B4B 2 pcs	8/30/19	0.00 0.00	QC 6 - 61	
			QC 6 - 40	
			QC 6 - 81	
			Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
170 QC 21 - SA	8/30/19	0.00 0.00	QC 21 - SA - 21	
			QC 21 - SA - 70	
			QC 21 - SA - 53	

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SEP 05 2019

Part Op 100 - 1-Machine as per DWG. 2-Debur
 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - QC8- Inspect parts - second check
 130 - Issue P/O : 44344 -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 4140 -Certificate of Conformity is required
 140 - (Receive & Inspect for Damage & Mat'l Certs) Certificate of Conformity is required
 150 - QC6- All purchased or subcontracted products
 160 - Identify as per dwg & Stock Location:
 170 - QC21- Final Inspection - Work Order Release

GA134

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R1.125	AISI 4140 Quenched & Tempered Steel Round Bar 1.125" Dia.	.0320 ft (.016 ea)	100-Conventional Lathe - 1	S053644

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Conventional Lathe - 1	MT-4140QT-R1.125	0	17	0

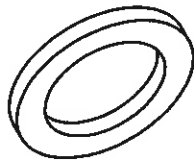
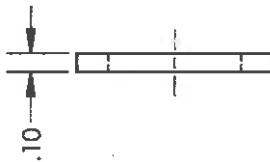
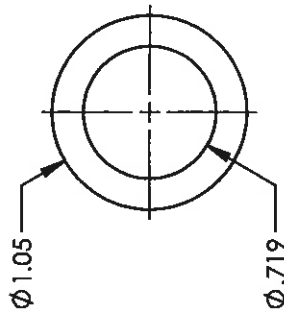
Part Specifications

Specifications could not be found.

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REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0065	-9 CHD MATERIAL WAS 4140 IS 4140/4142 Q&T. CHD FINISH WAS CAD PLATE. YELLOW IS ZINC PLATE. SPEC. ASTM B633 TYPE I SC2.	2/5/2016	RJC	SM



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 198239 M5
190724



MOUNTING TOOL

DWG NO.	RBE105-31702W19-9	REV	2
MAT'L	4140/4142 Q & T	UNLESS OTHERWISE SPECIFIED	
FINISH	ZINC PLATE	DIMENSIONS ARE IN INCHES	
SPEC	ASTM B633 TYPE I SC 2	XXX ± .006 FRACTIONS ± 1/16	
DRAWN BY:	SMITH	XX ± .01 ANGLES ± 5°	
CHECKED:	CLOUGH	X ± .1 SURFACES ± 125	
OPPS APPR:	ANDERSON	1. BREAK ALL SHARP EDGES	
QA APPR:	LINDSAY	2. DIMENSIONAL LIMITS APPLY	
APPROVED:	MACKOVJAK	3. INTERPRET DIM AND TOL PER	
SCALE	1:1	ASME Y14.5M-2009	
DATE	9/27/2013	USED ON MODEL	
		EC145	
		SHEET 6 OF 11	

⑨

WASHER

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐							
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QS1042) _____					
Description Work Order Deviation				Disposition							
Completed By				Lead hand / Supervisor							
								QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			



Dart Aerospace Ltd.
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PURCHASE ORDER

POHB044344



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044344

PO Date: 8/26/19

Due Date: 9/4/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-08-28

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	198074	RBW6305G11731-3G-01	Body Outsource13 (Outside Processing - Zinc Plating) -Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 1018 -Certificate of Conformity is required	Firmed	-	9/4/19	6 pcs	0 pcs	6 pcs	\$15.00/pcs	\$90.00
				Xle							DP
											5206519
2	197596	RB T101880	Tool Sleeve Outsource13 (Outside Processing - Zinc Plating) -Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 4140 -Certificate of Conformity is required	Firmed	-	9/4/19	1 pcs	0 pcs	1 pcs	\$4.7368/pcs	\$4.74
				XI							DP
											SEP 03 2019
											5198758



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PURCHASE ORDER

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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	198230	RBE105-31702W19-15	Handle Collet -Issue P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; Stress Proof -Certificate of Conformity is required	Firmed	-	9/4/19	6 pcs	0 pcs	6 pcs	\$4.7368/pcs	\$28.42
4	198236	RBE105-31702W19-11	Nut -Issue P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 4140 -Certificate of Conformity is required	Firmed	-	9/4/19	6 pcs	0 pcs	6 pcs	\$4.7368/pcs	\$28.42
5	198239	RBE105-31702W19-9	Washer -Issue P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 4140 -Certificate of Conformity is required	Firmed	-	9/4/19	6 pcs	0 pcs	6 pcs	\$4.7368/pcs	\$28.42
Grand Total:											\$180.00

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PURCHASE ORDER

POHB044344



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/28/19 9:13 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(021886-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

021886 - 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
29-Aug-2019		SPARTAKOS BOUNTOURIS		POHB044344					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	Quantités / Quantities À venir / Back Order	
2	RB T101880 Rev.	RB T101880 ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS AS PER B633 TYPE - 1, SC - 2 0.0003 "	ZINC CH	1	1	0	0	0	
3	RBE105-31702W19-15 Rev.	RBE105-31702W19-15 ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS AS PER B633 TYPE - 1, SC - 2 0.0003 "	ZINC CH	6	6	0	0	0	
4	RBE105-31702W19-11 Rev.	RBE105-31702W19-11 ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS AS PER B633 TYPE - 1, SC - 2 0.0003 "	ZINC CH	6	6	0	0	0	
5	RBE105-31702W19-9 Rev.	RBE105-31702W19-9 ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS AS PER B633 TYPE - 1, SC - 2 0.0003 "	ZINC CH	6	6	0	0	0	

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SEP 03 2019

DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

Euxel